Thursday, 11/8/2007 8:01:14 AM Date: Jean-Luc Menard User **Process Sheet** : CONSOLE TRIM ANGLE **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Job Number : 35583 : 10228 **Estimate Number** : D2163 Part Number P.O. Number D2163 REV. B S.O. No. : 1) A **Drawing Number** 11/8/2007 This Issue N/A Project Number : NC Prsht Rev. **Drawing Revision** MACHINED PARTS : 11/6/2007 First Issue : NA Material **Previous Run** Qty: 40 Um: Each : 12/20/2007 Due Date Written By Checked & Approved By Clarify IPP : EstF 02:05.11 Comment **Additional Product** Job Number: Description: **Machine Or Operation:** Seq. #: 5052-H32 .050 Sheet M5052H32S050 1.0 3.8637 2.9148 sf(s) Total: 0.0729 sf(s)/Unit Comment: Qty.: Material: 5052-H32 (QQ-A-250/8) 0.050" thick Batch: 14050 (M5052H32S.050) WATER JET 2.0 Comment: FI OW WATER JET 1-Cut as per Dwg D2163 B 07-11-12 Dwg Rev: Prog Rev:_ BO)-11-13 2-Deburr if necessary INSPECT PARTS AS THEY COME OFF MACHINE QC2 3.0 1B 07-1172 PARTS AS THEY COME OFF MACHINE Comment: INSPECT SECOND CHECK 4.0 QC8 Comment: SECOND CHECK NC BRAKE BRAKE NC 5.0 D 07/12/03 Comment: NC BRAKE Form as per QSI 003 and Dwg D2163

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	Thursday, 11/8/2007 8:01:14 AM Jean-Luc Menard	Process Sheet
Custon	ner: CU-DAR001 Dart Helicopters Services	Drawing Name: CONSOLE TRIM ANGLE
		Deat Number: D2163
Job Numl Job Number:	per: 35583	Part Number: D2163
JOD HUITIDGE		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP
		courtes
	mment: INSPECT WORK TO CURRENT ST	TEP DEPTH DE
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	A MAN ENNOUNCE PERCURSE #4	
Co	mment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 00	54.1 FR 07/12/05 (5)
8.0	POWDER COATING	POWDER COATING
		M100700 (S3X)
Co	mment: POWDER COATING Powder Coat Black Sandtex (Ref. 4.	357) as nor OSI 00543 M-1 07/12/05
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
E		7/
Co	mment: INSPECT POWDER COAT	PK 67-12-05
10.0	PACKAGING 1	PACKAGING RESOURCE #1
Co	Identify and Stock	
	Location:/	7/12/06 SP (53x)
11.0	QC21	FINAL INSPECTION/W/O RELEASE
Co	omment: FINAL INSPECTION/W/O RELEAS	
Job Completio	n little in the state of the st	C1 57-12-06
		Ca Dtiles
Page 2		Form: rprocess

DART AEROSPACE LTD	Work Order:	35583
Description: Trim Angle	Part Number:	D2163
Inspection Dwg: D2163 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST							
	X	First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	mments
8.165	+/-0.010	8.169	X				
R0.375	¿+/-0.010	375	×				
Ø0.098	+0.005/-0.000	1099	×				
0.250	+/-0.010	.3So	×				
0.580	+/-0.010	.580	8				
1.121	+/-0.010	161.1					<u>.</u>
0.050	+/-0.010	,048	\				
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							- deliktro u
							The Additional Security and Company of the Company
							
			·				
				2			
Measured by: 18		Audited by:			Prototype Appro	oval:	N/A
	07-11-12	Date:	/	13	C	Date:	N/A

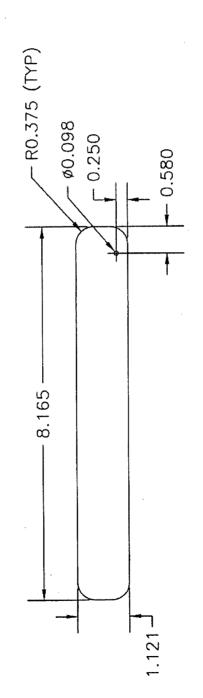
Rev	Date	Change	Revised by	Approv é d
Α	05.05.10	New Issue	KJ/JLM	(J.)]



		. 1			
DESIGN		<u> </u>	BW	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
	CHÉCI	(EO	APPROVED	DRAWING NO. R	REV. 8
		KE	194	D2163 SHEET 1	0F ,1
-	DATE	<u></u>		TITLE	SCALE
	97.1	0.30		TRIM ANGLE	1:2
	Α		95.05.19	RE-DRAWN	*************
	В		97.10.30	REMOVE BEND DATA	



75.



5052-H32 (QQ-A-250/8) 0.050 THICK POWER COAT MATTE BLACK PER DART QSI 005 4.3 MATERIAL: FINISH:

SHOP COPY

RETURN TO

ENGINEERING

INCONTROLLED COF

SUBJECT TO AMENDMEN

WITHOUT NOTICE

NO. 3558